

Work Order ID 52818

October 15, 2009 9:40:56 AM

Page 1

Item ID: D3145-2

Accept

Revision ID: B

Item Name: Bracket

Start Date: 10/15/09 Start Qty: 1.00

Required Date: 10/19/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3145

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

DI 09/10/19

1

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per Folio FA318 and Dwg D3145 Deburr and Tumble

SL 09/10/19
NON DRILLED

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 09/10/19

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Page 2

Item ID: D3145-2

Accept

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Item Name: Bracket

Setup Start

Stop

Start Date: 10/15/09 Start Qty: 1.00

Required Date: 10/19/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Im/09.10.19

(1)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BF 09-10-19

(1)

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M112148
START TIME: *9:00*
320° FINISH TIME:

OVEN TEMPERATURE:

9:30

BF 09-10-19

(1)

Work Order ID 52818

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Page 3

Item ID: D3145-2

Accept

Revision ID: B

Item Name: Bracket

Start Date: 10/15/09 Start Qty: 1.00

Required Date: 10/19/09 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W 09.11.02

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

*for Helicorp PTY
order # 4461*

9/11/02 54

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/02

W 09.11.02

Picklist Print

October 15, 2009 9:40:55 AM

Page 1

Work Order ID: 52818

Parent Item: D3145-2RevB

Parent Item Name: Bracket

Start Date: 10/15/09

Required Date: 10/19/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	13.3259	0.4035			



6061-T6 Bar 2.00 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

13.32586316

110167

0.532

13085

10.903

17124

1.89086316

0.4035 DJP 09/10/19

DART AEROSPACE LTD		Work Order: 52818
Description: Bracket		Part Number: D3145-2
Inspection Dwg: D3145	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.188	+/-0.010	.188	✓			
0.125	+/-0.010	.122	✓			
1.636	+/-0.010	1.646	✓			
0.125	+/-0.010	.135	✓			
0.766	+/-0.010	.766	✓			
0.250	+/-0.010	.248	✓			
1.370	+/-0.010	1.369	✓			
0.760	+/-0.010	.760	✓			
4.303	+/-0.010	4.300	✓			
0.125	+/-0.010	.135	✓			
0.219	+/-0.010	_____				
R0.125	+/-0.010	0.125	✓			
1.960	+/-0.010	1.961	✓			
1.250	+/-0.010	_____				
0.180	+/-0.010	_____				
R0.250	+/-0.010	0.250	✓			
0.240	+/-0.010	_____				
0.108	+/-0.010	.108	✓			
Ø0.221 x 0.351	+/-0.010	_____				

Measured by:	JL
Date:	09/10/19

Audited by:	[Signature]
Date:	09.10.19

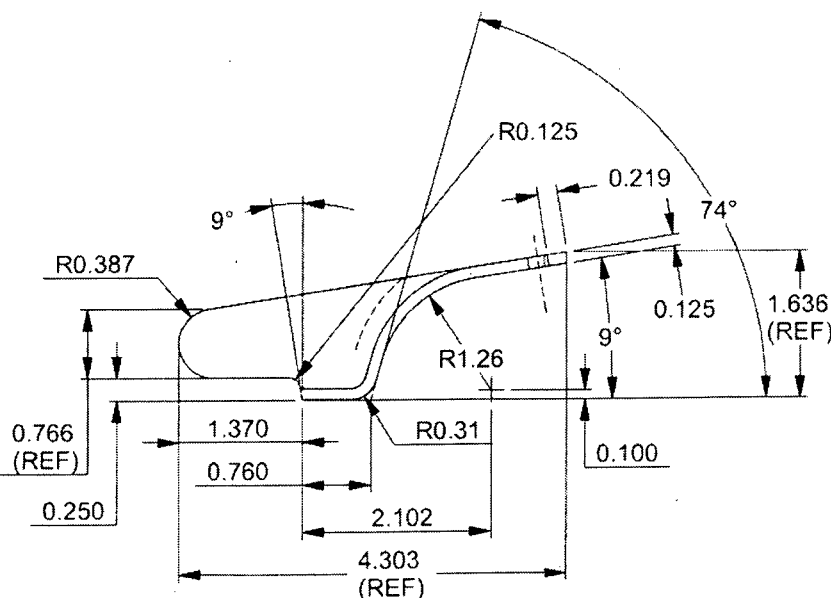
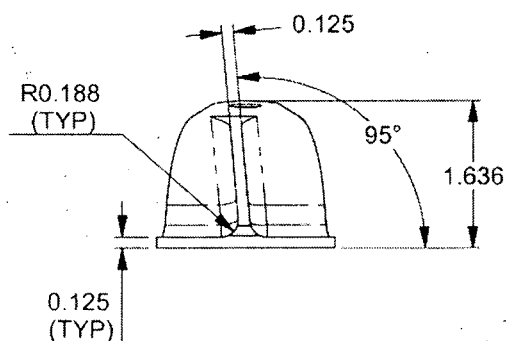
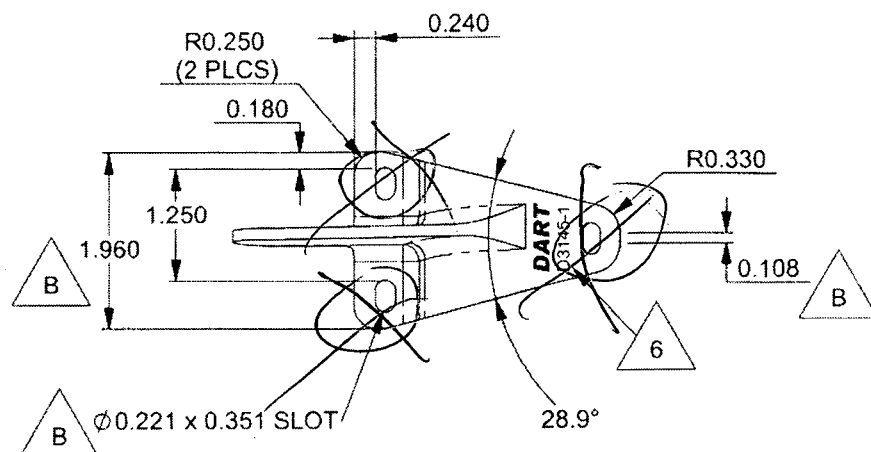
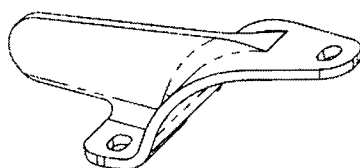
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	[Signature]

Robbin wlo 52818



DESIGN #	DRAWN BY P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06	TITLE BRACKET		SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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